

# Work Order ID 106970

\*106970\*

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September-12-13 8:09:23 AM

Item ID: D4821-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Windshield Deflector

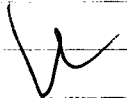
Start Date: 9/12/13 Start Qty: 2.00 \*2\*

Cust Item ID:

Required Date: 9/24/13 Req'd Qty: 2.00 \*2\*

Customer:

Reference:

Approvals: Process Plan:  Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4821	A								
100	Cut blanks as per folio	0.00							
*100*									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT BLANK AT 51.000"								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
*110*									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine per folio FB187								
	DWG REV: A								
	FOLIO REV: A4								
	2- deburr and break all sharp edges								

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Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00 0.00		mk13/09/25		2	0		
130 *130* QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		13-09-26		2	0		
131 *131* HandFinish Hand Finishing	 Memo CLEAN AND REMOVE ALL PART MARKING	0.00 0.00		N/A					CL13/09/27

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Revision ID:

Stop **\*NS2\***

Item Name: Windshield Deflector

Start Date: 9/12/13 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 9/24/13 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
<b>*140*</b>									
Outsource4	Memo	0.00							
Outsource process - Anodize	Issue P/O: <u>21510</u> Black Anodize as per Dwg D4821 pRIME AS PER DWG AS PER NOTE 2								<u>CZ 13/09/22</u> (2)
150	Receive & Inspect for Damage & Mat'l Certs	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							<u>P 13/1/22</u> (2)
Packaging									
152	QC 4- Inspect Spray Paint	0.00							
<b>*152*</b>									
QC	Memo	0.00							
Quality Control									<u>2</u>

DAS  
27  
9-89

B.D. 22

**Work Order ID 106970****\*106970\***

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September-12-13 8:09:23 AM

Item ID: D4821-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Windshield Deflector

Start Date: 9/12/13 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 9/24/13 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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155

QC5- Inspect part completeness to step on W/O

0.00

**\*155\***

QC

Memo

0.00

Quality Control

DAS  
27  
9-89

180

Identify as per dwg & Stock Location: ~~ST436~~

0.00

**\*180\***

Packaging

Memo

ST139F

0.00

Packaging

2X

DAS  
28  
9-89

13-10-22

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

HJ/Rm 13/10/29.

13-10-22

# Picklist Print

September-12-13 8:09:23 AM

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Work Order ID: 106970

Parent Item: D4821-1

Parent Item Name: Windshield Deflector

Start Date: 9/12/13

Required Date: 9/24/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV: A NEW ISSUE 13/04/25 JFS VERIFY BY: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6B3.500X02.000 7075-T6 BAR 3.500' X 2.000"		Purchased	No			100	f	11.0500	4.25	8.9473684			

Location

Loc Qty

Loc Code

MAT001

11.05

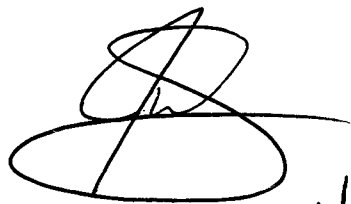
→ 123555

8

125363

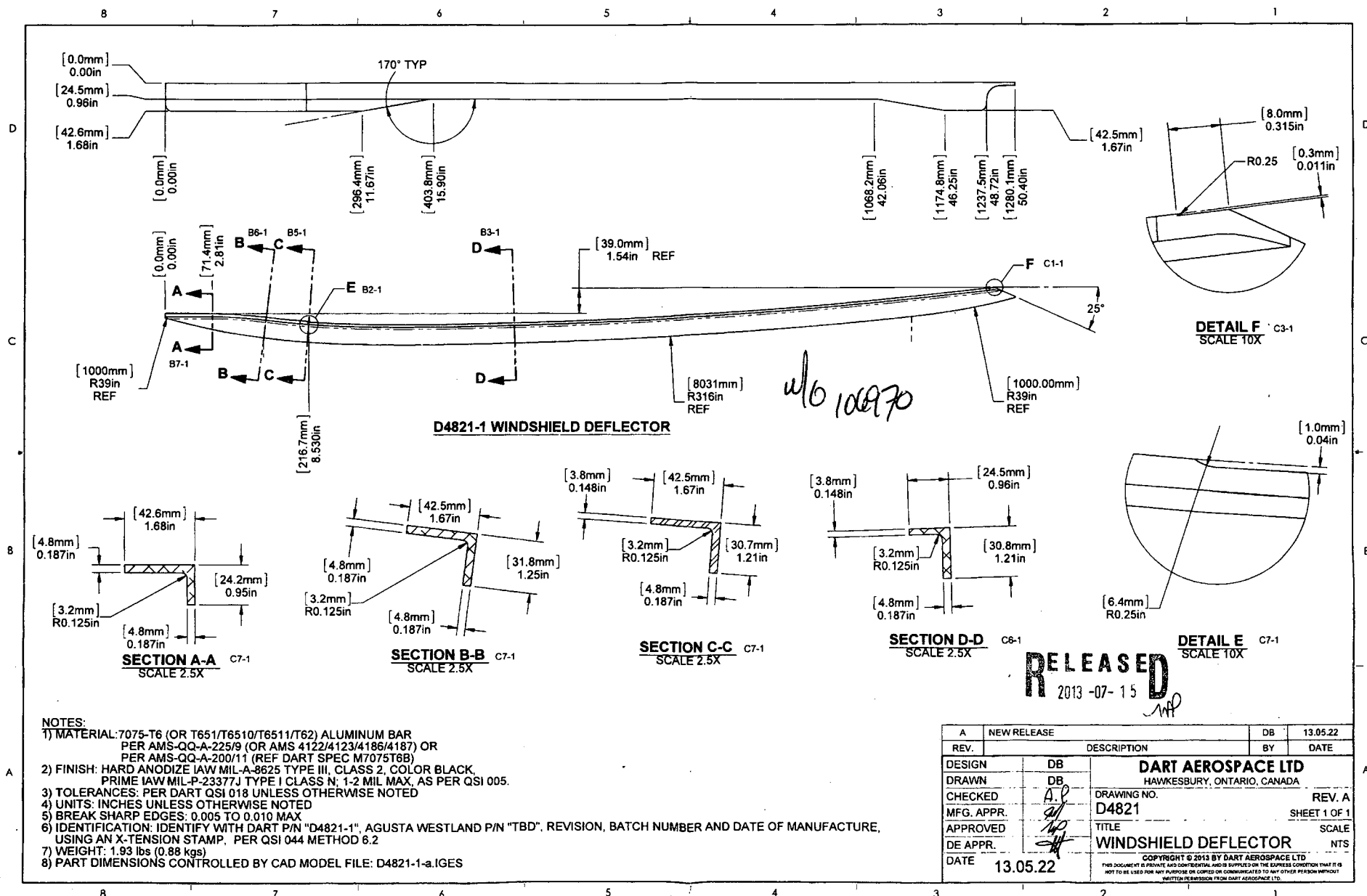
3.05

4.5 out 13/08/24



M7075-T6 B4.00X3.00 M125584 → 4.5

This Pickit only



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 106970
<b>Description:</b> WINDSHIELD DEFLECTOR		<b>Part Number:</b> D4821-1
<b>Inspection Dwg:</b> D4821 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.96	$\pm 0.30$	.970	—		Vern	ML-06
1.68	$\pm 0.30$	1.678	—		"	
11.67	$\pm 0.30$	11.670	—		M-type	ML-08
46.25	$\pm 0.30$	46.250	—		"	
50.40	$\pm 0.30$	50.400	—		"	
.011	$\pm 0.10$	.009	—		Vern	ML-06
.187	$\pm 0.10$	.192	—		"	
.95	$\pm 0.30$	.950	—		"	
.187	$\pm 0.30$	.192	—		"	
R.125	$\pm 0.10$	R.125	—		R-G	
1.67	$\pm 0.30$	1.678	—		Vern	ML-06
1.25	$\pm 0.30$	1.253	—		"	
.148	$\pm 0.10$	.148	—		"	
1.21	$\pm 0.30$	1.215	—		"	
.04	$\pm 0.30$	.040	—		"	

<b>Measured by:</b> <i>am</i>	<b>Audited by:</b> <i>st</i>	<b>Preliminary Approval:</b>
<b>Date:</b> 13/09/25	<b>Date:</b> 13-09-26	<b>Date:</b>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

*10.04.15*



A.T.G. Industries Inc.  
731, rue Industrielle Rd.  
PLATING DEPARTMENT  
Rockland, On K4K 1T2  
Canada  
Ph: (613) 446-4544  
Fax: (613) 446-4556

### Pack List

Number: 62694

Date: 21-Oct-13

#### To

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
Canada

#### Ship To

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7  
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
1 lot	Part: ASST 2 PCS 646.2910 (48.00) 4 PCS 646.3110 (10.65) 6 PCS 646.3811 (6.55) 35 PCS 646.9910 (13.40) 32 PCS 647.2010 (11.90) 2 PCS D4821-1 (50.25) 7 PCS D4823-1 (11.15) 2 PCS D4824-1 (13.40)  HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2  PRIME MIL-P-23377J TYPE I CLASS N  PRICE IS PER PIECE Job: 20130656	Rev:	
		PO: 21510	Line:
Certificate of Conformance  A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order.  ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY  DATE: <u>2/10/13</u>  CERTIFIED SIGNATURE: <u>[Signature]</u>  RECEIVER SIGNATURE: _____			